



Operator Instructions Includes - Foreseen Use, Work Stations, Putting into Service, Operating, Dismantling, Assembly and Safety Rules	Important Read these instructions carefully before installing, operating, servicing or repairing this tool. Keep these instructions in a safe accessible place.
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Manufacturer / Supplier Sioux Tools Inc. 2901 Floyd Boulevard P.O. Box 507 Sioux City Iowa 51102 U.S.A. Tel No 712-252-0525 Fax No 712-252-4267	Product Type 3" Cut Off Tool	RPM 22,000 Cycles Per Min	
	Model No/Nos 5564	Serial No	

Product Net Weight 1.93 lbs 0.88 Kg	Recommended Use Of Balancer Or Support No	Recommended Hose Bore Size - Minimum 1/4 Ins 10 M/M	Recommended Max. Hose Length 30 Ft 10 M
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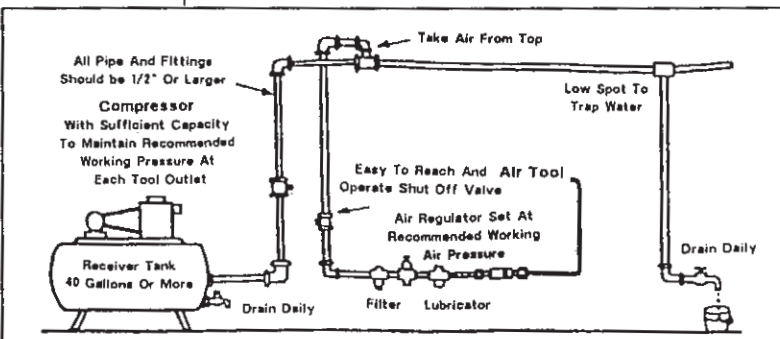
Air Pressure Recommended Working 6.2 bar 90 PSIG Maximum 6.2 bar 90 PSIG	Noise Level Sound Pressure Level 93.0 dB(A) Sound Power Level 104.0 dB(A) Test Method Tested in accordance with Pneurop test code PN8NTC1 and ISO Standard 3744
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Personal Safety Equipment Use - Safety Glasses Yes Use - Safety Gloves Yes Use - Safety Boots Use - Breathing Masks Yes Use - Ear Protectors Yes	Vibration Level Less than 2.5 Metres / Sec² Test Method Tested in accordance with ISO standard 8662/1
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Safety rules when using a 5564 Cut Off Tool

- Always wear safety goggles.
- Never use tool unless guard is fitted.
- Use discs rated at above 25,000 RPM.
- Prolonged vibration may cause injury.
- Read all instructions before using this tool. All operators must be fully trained in its use and aware of these safety rules.
- Do not exceed the maximum working air pressure.
- Use personal protection equipment as recommended.
- Use compressed air only at the recommended conditions.
- If the tool appears to malfunction, remove from use immediately and arrange for service and repair. If it is not practical to remove the tool from service, then shut off the air supply to the tool and write or have written a warning note and attach it to the tool.
- If the tool is to be used with a balancer or other suspension device, ensure that the tool is firmly attached to the suspension/support device.
- When operating the tool, always keep the body and particularly the hands away from the working attachment affixed to the tool.
- The tool is not electrically insulated.

- Never use the tool if there is any chance of coming into contact with live electricity.
- Always when using the tool, adopt a firm footing and/or position and grip the tool sufficiently only to overcome any reaction forces that may result from the tool doing work. Do not overgrip.
- Use only approved spare parts for maintenance and repair. Do not modify or make temporary repairs. Major servicing and repairs should only be carried out by persons trained to do so.
- Do not lock, tape, wire, etc. the 'On/Off' valve in the 'On' position. The trigger lever, etc. must always be free to return to the 'Off' position when released.
- Always shut off the air supply to the tool and press the 'On/Off' valve to exhaust the air from the feed



Recommended Air Supply System Figure 1

hose before fitting, removing or adjusting the working attachment fitted to the tool.

- Before using the tool make sure that a shut off device has been fitted to the supply line and the position is known and easily accessible so that the supply to the tool can be shut off in an emergency.
- Check hose and fittings regularly for wear.
- Take care against entanglement of the moving parts of the tool with clothing, hair, ties, cleaning rags, rings, jewelry, watches, bracelets, etc. This could cause the body or parts of the body to be drawn towards and in contact with the moving parts of the tool and could be very dangerous.
- It is expected that users will adopt safe working practices and observe all local, regional or country legal requirements when installing, using or maintaining the tool.
- Take care that the exhaust air does not point towards any other person or material or substance that could become contaminated by oil droplets. When first lubricating a tool or if the tool exhaust has a high oil content, do not allow the exhaust air to come near very hot surfaces or flames.
- Never lay the tool down until the working attachment has stopped moving.
- When the tool is not in use, shut off the air supply and press trigger/lever to drain the supply line. If the tool is not to be used for an extended period of time, first lubricate, disconnect from air supply and store in a dry average room temperature environment.
- If the tool is passed from one user to a new or inexperienced user, make sure these instructions are available to be passed with the tool.
- Do not remove any manufacturer fitted safety devices where fitted, i.e. wheel guards, safety trigger, speed governors, etc.
- Where ever possible, secure workpiece with clamps, a vise, etc. to make it rigid so it does not move during the work operation. Keep good balance at all times. Do not stretch or overreach.
- Try to match the tool to the work operation. Do not use a tool that is too light or heavy for the work operation. If in doubt, seek advice.
- In general terms this tool is not suitable for underwater use or use in explosive environments--seek advice from manufacturer.
- Try to make sure that the work area is clear to enable the work task to be performed safely. If practical and possible, try to clear unnecessary obstructions before starting work.
- Always use air hose and couplings with minimum working pressure ratings at least $1\frac{1}{2}$ times the maximum working pressure rating of the tool.

Foreseen Use of the Tool

This tool is designed to be used with flat reinforced resin $2\frac{7}{8}$ ins dia max discs having a speed rated above 25000 rpm. The bore size of the disc is $3/8$ ins.

The tool should not be used with and other type or rating of abrasive disc or wheel. It must never be used with saw blades or other cutting devices.

Do not use the tool outside the design intent. Never modify the tool for any other purpose, or for its use as a disc cutter without first seeking advice from the manufacturer or an authorized representative.

Work Stations

The tool should only be used as a hand held hand operated tool. It is always recommended that the tool is used when standing on a solid floor. It can be used in other positions but before any such use the operator must be in a secure position having a firm grip and footing and be aware of the safety rules to be obeyed when using the cutter.

Air Supply.

Use a clean lubricated air supply that will give a measured air pressure at the tool of 90 PSIG (6.2 bar) when the tool is running with the trigger/lever fully depressed. Use recommended hose size and length. It is recommended that the tool is connected to the air supply as shown in figure 1. Do not connect the tool to the air line system without incorporating an easy to reach and operate air shut off valve. The air supply should be lubricated. It is strongly recommended that an air filter, regulator, lubricator(FRL)is used as shown in Figure 1 as this will supply clean, lubricated air at the correct pressure to the tool. Details of such equipment can be obtained from your supplier. If such equipment is not used then the tool should be lubricated by shutting off the air supply to the tool, depressurizing the line by pressing the trigger on the tool. Disconnect the air line and pour into the hose adaptor a teaspoonful(5ml) of a suitable pneumatic motorlubricating oil preferably incorporating a rust inhibitor. Reconnect tool to air supply and run tool slowly for a few seconds to allow air to circulate the oil. If tool is used frequently lubricate on daily basis and if tool starts to slow or lose power.

It is recommended that the air pressure at the tool while the tool is running is 90 PSIG(6.2 bar).

Operating

The lever(12)is the on/off valve for the tool. Connect to a suitable air supply and ensure that the air pressure. Measured at the tool inlet. With the tool running does not exceed 90 PSIG (6.2 bar). Select disc type and ensure that the disc is not cracked or damaged and that the speed rating of the disc is in excess of 25,000 rpm. Using only the spacer(30)supplied with the tool. fit the disc and tighten wheel screw(31)while holding nut(28). Do not over tighten as this could crack the disc. Ensure wheel cover(27)is in place. When first starting the tool with a new or changed disc the tool should be first started in a protected area i.e. such as under a heavy bench and run for say a minimum time of one minute. This will provide protection if the wheel should break because a fault was not detected. Always use eye protection and wear protective gloves. Remember that the cutting process will generate heat and that cut parts, particularly small items can get very hot and burn fingers if touched. Allow cut parts to cool.

The tool and the work process may create a noise level such that ear protectors should be worn. The cutting process will create dust and the use of breathing masks is recommended. Check that the material being cut will not cause harmful dust or fumes. If this is so then special breathing apparatus may be required. Seek advice before starting work. The cutting process will create sparks. Ensure that these do not create a hazard to any person, object or process and are not directed near any flammable materials or fluids. Do not use the cutter in explosive environments. Do not apply excessive loads to the tool as this will reduce the efficiency of the disc. Apply light loads and allow the wheel to cut. Try always to keep the disc square to the cut. Do not apply side loads or grind on the side of the disc. Handle the cutter with care. If the cutter is dropped carefully examine the disc for damage and replace if necessary. Start the tool as for the first time of fitting a disc, i.e. under a bench. Make sure that the object to be cut is in a firm fixed position.

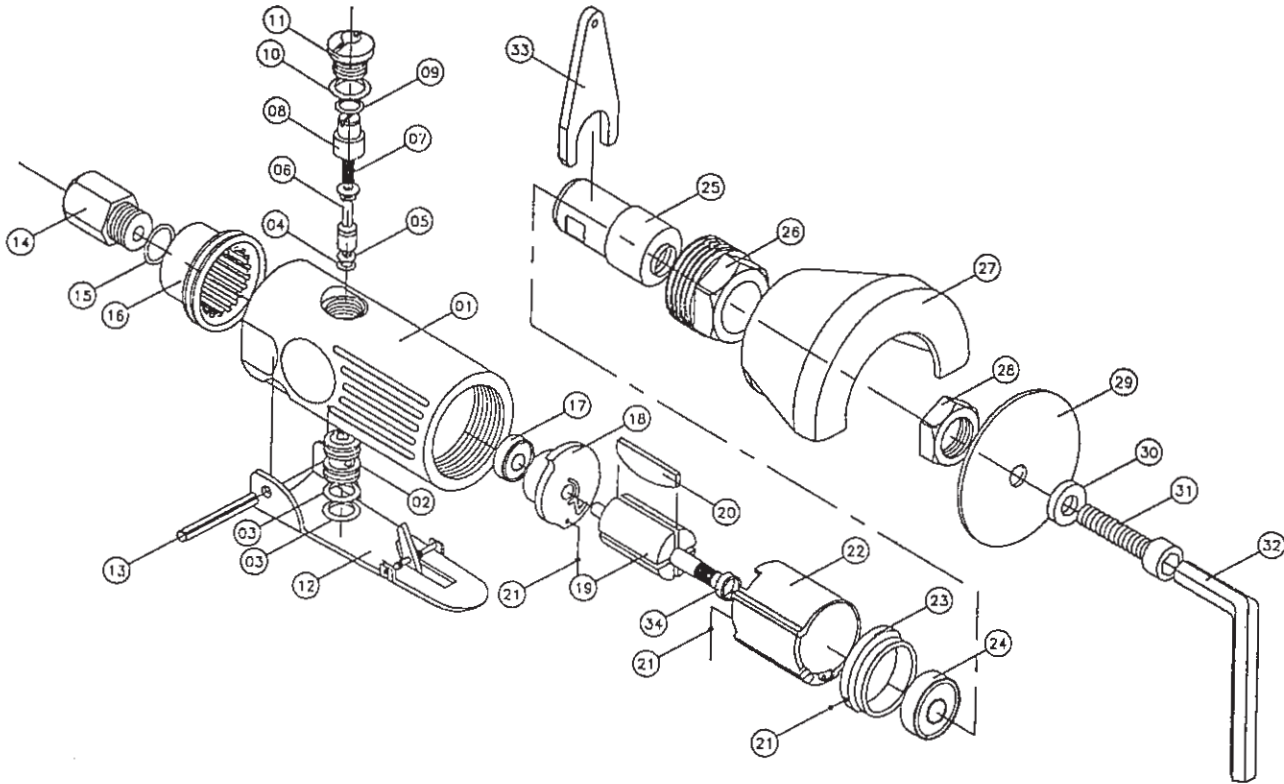
Dismantling & Assembly Instructions

Disconnect tool from the air supply.

Grip chuck spindle(25)With spanner(33)and with hex wrench (32)unscrew hex screw(31)and take off cutting wheel disc(29) and spacer(30). Grip housing(1)by the flats at the rear end and



5564 3" Cut Off Tool



Ref No	Part No	Description
1	66436	Housing
2	66444	Bushing-Throttle Valve
3	66518	O-Ring(2)
4	66442	O-Ring
5	66451	O-Ring
6	66443	Pin-Throttle
7	66441	Spring
8	66440	Air Regulator
9	66464	O-Ring
10	66438	O-Ring
11	66437	Valve Plug
12	66445	Safety Throttle Lever
13	66446	Pin
14	66469	Hose Adaptor
15	66429	O-Ring
16	66448	Muffler
17	66435	Ball Bearing

Ref No	Part No	Description
18	66434	Rear End Plate
19	66432	Rotor
20	66433	Rotor Blade(4)
21	66414	Steel Ball(3)
22	66430	Cylinder
23	66428	Front End Plate
24	66427	Ball Bearing
25	66419	Chuck-Spindle
26	66424	Nut-Clamp
27	66452	Wheel Cover
28	66423	Nut
29	2003	Cutting Wheel
30	66420	Spacer
31	66421	Hex Screw
32	66422	Hex Wrench
33	66478	Spanner
34	66400	Spacer

unscrew nut(28)and take off wheel cover(27). Unscrew and remove nut clamp(26)from housing(1)and grip chuck spindle(25) and pull out complete with the motor assembly.

Grip or locate on the cylinder(22)side of rear end plate(18)and tap the rear end of rotor(19)to drive it through the rear end plate(18) and bearing(17)assembly. With a suitable punch tap out bearing(17) from rear end plate(18). Take off cylinder(22)and at this time note for reassembly how 2 off balls(21)in rear end plate(18)and front end plate(23)locate the cylinder(22)and how ball(21)in the side of front end plate(23)locates the complete motor assembly to motor housing(1)via the slot in the front bore of that housing.

Take out 4 off rotor blades(20)from rotor (19). Grip the rotor(19) carefully so as not to damage it or raise burrs on it and unscrew chuck spindle(25)to release front end plate (23) and bearing(24) assembly and spacer(34). With a suitable punch tap out bearing(24) from front plate(23).

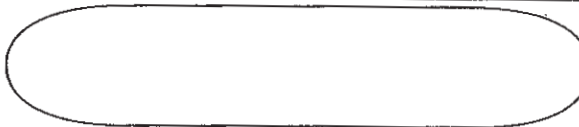
Drive out pin(13)and remove lever(12). Unscrew hose adaptor with screen(14)with O-ring(15)and pull out muffler(16). With a wide bladed screwdriver unscrew valve plug(11)and take out air regulator (8)with O-rings (9)&(10). spring (7) and pin throttle (6) with O-rings(4)&(5). Remove O-rings(4)&(5)from pin throttle(6). If a replacement is required push out bushing throttle valve(2)with O-rings(3). Remove O-rings(3)from bushing(2).

Reassembly

Clean all parts and examine for wear and replace any parts with parts obtained from the manufacturer or an approved distributor. Ensure that the faces of end plates(18)and(23)that abut cylinder (22)are flat and free from burrs and surface defects. If necessary lap on a flat very fine grade of abrasive paper. Lightly coat all parts with a suitable pneumatic tool lubricating oil and pack bearings with a lithium or molybdenum based general purpose grease and assemble in the reverse order. With the lever(12)depressed pour into hose adaptor(14)5ml of a suitable pneumatic motor lubricating oil. Release lever and connect to a suitable air supply and run tool slowly for 2 to 3 seconds to allow the oil to circulate. Check that the safety lever and air regulator operate correctly. Ensure wheel cover(27)is tightly secured by nut(28). Before fitting a new disc(29)make sure that the disc is undamaged and has the correct speed rating and check the speed of the tool at an air pressure of 90 PSIG(6.2. bar)measured at the tool inlet when the tool is running free does not exceed 22,000 rpm. See section "Operating".

Notes

Operation Specification	
Air Consumption	40cfm(28 scfm)
Air Inlet Thread	1/4-18NPT
Overall Length	7 $\frac{1}{4}$ "(181mm)
at 90 PSIG	



Declaration of Conformity

Sioux Tools Inc.

2901 Floyd Boulevard, P.O. Box 507, Sioux City, Iowa 51102

declare under our sole responsibility that the product

Model 5564 3" Cut Off Tool, Serial Number

to which this declaration relates is in conformity with the following standard(s) or other normative document(s)

EN792 (Draft), EN292 Parts 1 & 2, ISO 8662 Parts 1, Pneurop PN8NTC1

following the provisions of **89/392/EEC as amended by 91/368/EEC & 93/44/EEC Directives**

R V Caskey(President)

Place and date of issue

Name and signature or equivalent marking of authorized person

This pdf incorporates the following model numbers:
5564